

Work Order ID 129583

February-17-15 11:37:56 AM

129583

Page 1

Item ID: D2734 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step End Plate
 Start Date: 2/17/15 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2734	Rev C

100	FLOW WATER JET	0.00				60	0		Jm15-2-19
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100
 Waterjet
 FLOW CNC Waterjet
5052-063

Memo
 1-Cut as per Dwg D 2734
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00				60	0		Jm15-2-19
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110
 QC
 Quality Control

Memo

120	QCS- Inspect parts - second check	0.00				60			
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120
 QC
 Quality Control

Memo

DAS
 38
 9-89
 FEB 20 2015

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00			DAS 30 9-89	60			15/02/23
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Form as per drawing D2734								
140		0.00							DAS 38 9-89
140	QC5- Inspect part completeness to step on W/O					(60)			
QC	Memo	0.00							
Quality Control									FEB 24 2015
150		0.00							
150	Identify as per dwg & Stock Location <u>WA03</u>					60			DH 15/2/24
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								

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Required Date: 3/06/15 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

15/2/25

AS-225

Picklist Print

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Parent Item: D2734

D2734

Parent Item Name: Step End Plate

Start Date: 2/17/15

Required Date: 3/06/15

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: D01.06.08Removed DeburrEC

IPP Rev:E 07-12-18 RevC as per dwg ECN1048 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.063

Purchased

No

100

sf

56.7015

0.0625

3

M5052H32S 063

**

Jm15-2-19

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

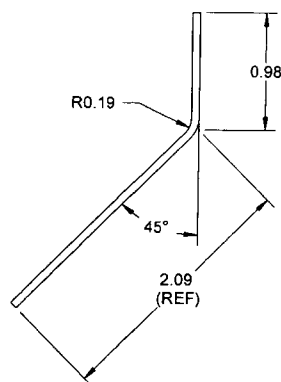
MAT022

56.7015

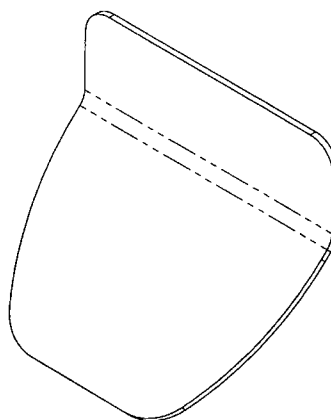
M128455

56.7015

128455



D2734 END PLATE



D2734 FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T6) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

RELEASED
07.12.16

C	ADD GRAIN DIRECTION NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.20
B	0.976 WAS 1.016, 2.097 WAS 2.137	KE	98.10.05
A	NEW ISSUE	KE	97.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2734 TITLE END PLATE SCALE 1:1 COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.20		